

shp forey

Page 1

Item ID: 646.9601

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: UPPER CUTTER ASSY

Start Date: 7/04/13 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 7/04/13 Req'd Qty: 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
646.9600	N/C

110	Pick Kit	0.00
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110

Packaging

Packaging

Memo

0.00

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 125306
exp. date: 12/14

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Quality Control

Memo

0.00

DAS
05 13.07.04
~~8.08~~

DAS
05
8-89/13-07-04

① 120704

Work Order ID 103911

103911

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July-04-13 9:53:27 AM

Item ID: 646.9601 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: UPPER CUTTER ASSY
 Start Date: 7/04/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/04/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

① 13 07-04

13/7/4

ME

13-7-04

Picklist Print

July-04-13 9:53:26 AM

Page 1

Work Order ID: 103911

Parent Item: 646.9601

Parent Item Name: UPPER CUTTER ASSY

Start Date: 7/04/13

Required Date: 7/04/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 Cutter Sub Assembly		Manufactured	No			110	Each	50.0000	1	①		7/13/07/04	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MF		50							
				89707		10							
				91287		26							
				91788		12							
				92558		2							
646.9811 Upper Deflector		Manufactured	No			110	Each	12.0000	1	①		7/13/07/04	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST437		12							
				89842		10							
				91277		2							
MS21042L08 Nut		Purchased	No			110	Each	3,604.0000	3	③		7/13/07/04	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST315		1604							
				122141		3							
				122452		9							
				122814		500							
				123900		1092							
				ST505		2000							
				125445		2000							

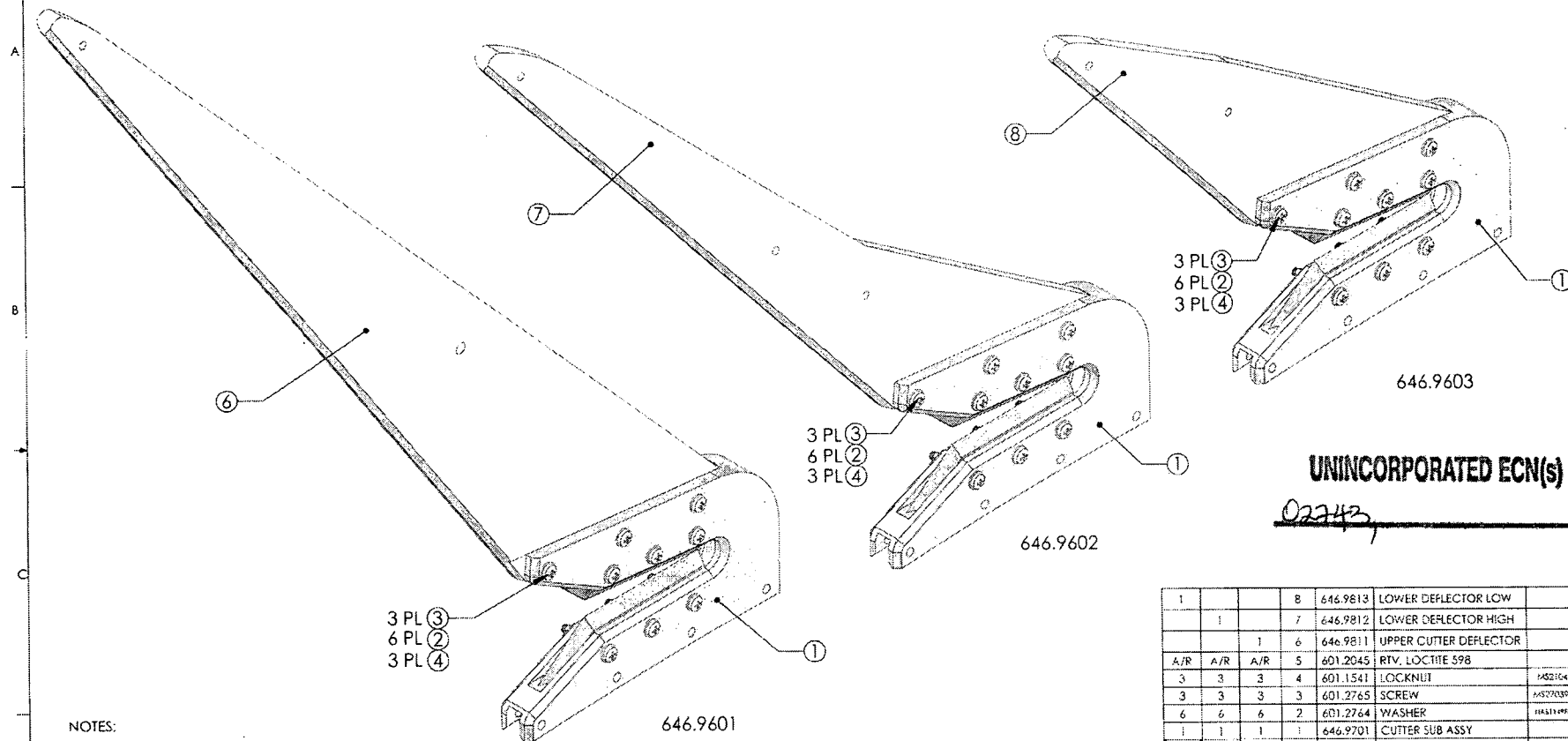
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600		REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: CUTTER ASSY					
	APPROVED BY:	ENGR <i>P. Brans</i>	MFG <i>Armit Gentry</i>	QC <i>Wendy Lezar</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH.					

w/o 10394

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROJECT REVISIONS PPT		TRC
REC	2004 RELEASE	04/30/00	P. BRADY



646.9603

UNINCORPORATED ECN(S)

02742

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1				B	646.9813	LOWER DEFLECTOR LOW			
	1			7	646.9812	LOWER DEFLECTOR HIGH			
		1		6	646.9811	UPPER CUTTER DEFLECTOR			
A/R	A/R	A/R		5	601.2045	RTV, LOCITE 598			
3	3	3		4	601.1541	LOCK NUT	M521042106		
3	3	3		3	601.2765	SCREW	M527039-0819		
6	6	6		2	601.2764	WASHER	M52104915079		
1	1	1		1	646.9701	CUTTER SUB ASSY			
					646.9603	LOWER CUTTER ASSY LOW			
					646.9602	LOWER CUTTER ASSY HIGH			
					646.9601	UPPER CUTTER ASSY			
.9603	.9602	.9601		FIND #	PART #	DESCRIPTION	MATL	SPEC	
GTY				PARTS LIST					
NEXT ASSY (S)				<div> <div> ORIGINAL DATE 12/01/01 </div> <div> DESIGNED BY J. JACKSON </div> <div> DRAWN BY J. JACKSON </div> <div> CHECKED BY J. JACKSON </div> <div> APPROVED BY J. JACKSON </div> <div> DATE 12/01/01 </div> </div> <div> <div> 646.9500 </div> <div> 646.9500 </div> </div>					
				<div> <div> APICAL INDUSTRIES </div> <div> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 </div> </div>					
				CUTTER ASSY					
				<div> <div> SIZE 1/2 </div> <div> PAGE CODE B </div> <div> DATE 07/26/02 </div> <div> DWG. NO. 646.9600 </div> <div> SCALE NONE </div> <div> REV. 1/0 </div> </div>					